

Date: Wednesday, 5/31/2006 7:37:35 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 BASKET BASE (SHORT)
Job Number	: 27292A		
Estimate Number	: 10209		
P.O. Number	: N/A	Part Number	: D3265041
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D3265 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 25094A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 6/30/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>06.05.31</u>		
Comment	: Est Rev:C Re-Format 05-11-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Qty 3 D3166-1 Basket Hoop Batch: B27326

PD 06/06/12

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing.
 (M304TS0.750W.065)
 Batch: M80111

PD 06/06/12

3.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:

Qty Part Number	Description	Batch
2 D2232-3	Hinge bracket	<u>B27527</u>

PD 06-06-16

4.0	D2325	Support Gusset (350 Bask
-----	-------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty Part Number	Description	Batch
4 D2325	Support Gusset	<u>B26741</u>

PD 06-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:37:35 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 27292A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B27051

PD

06-06-16

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B26204 -> 1

B27524 -> 1

PD

06-06-16

7.0

D34425

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3442-5

Shim

B24246

PD

06-06-16

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

26sf

M304EX0.75-16F Expanded Metal

M1009181

PD

06-06-21

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

PD

06-06-21

H:\Forms\Quality Assurance\approved forms\NCRWO revC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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User: Kim Johnston

Process Sheet

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Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 27292A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/06/21 ①

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/22 ①

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with White Sikaflex-291

Batch: M 101193

Expiry date: 11/2006

H.M 06-06-23 ①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/06/23 ①

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/06/23 ①

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/27 ①

Job Completion



DL 06/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



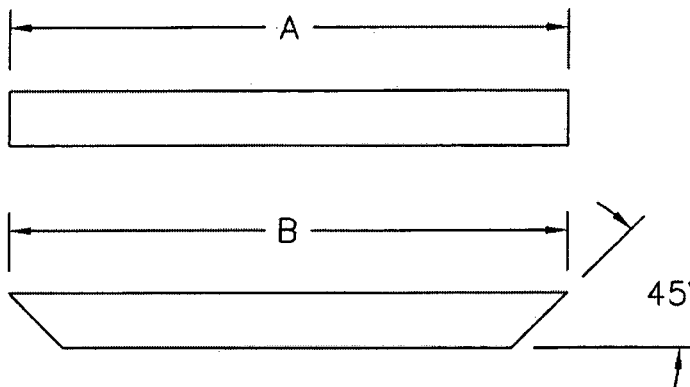
DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3265	REV. B SHEET 1 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED

05-08-19 #

PARTS LIST FOR D3265-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3265-1	2	—	56.75	RIB
D3265-3	2	—	25.50	RIB
D3265-5	2	27.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-5	2	N/A	N/A	SHIM



D3265-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING
D3265-041 BASE WITH D3267-041/-043 LID

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WITHOUT NOTICE

WORK ORDER

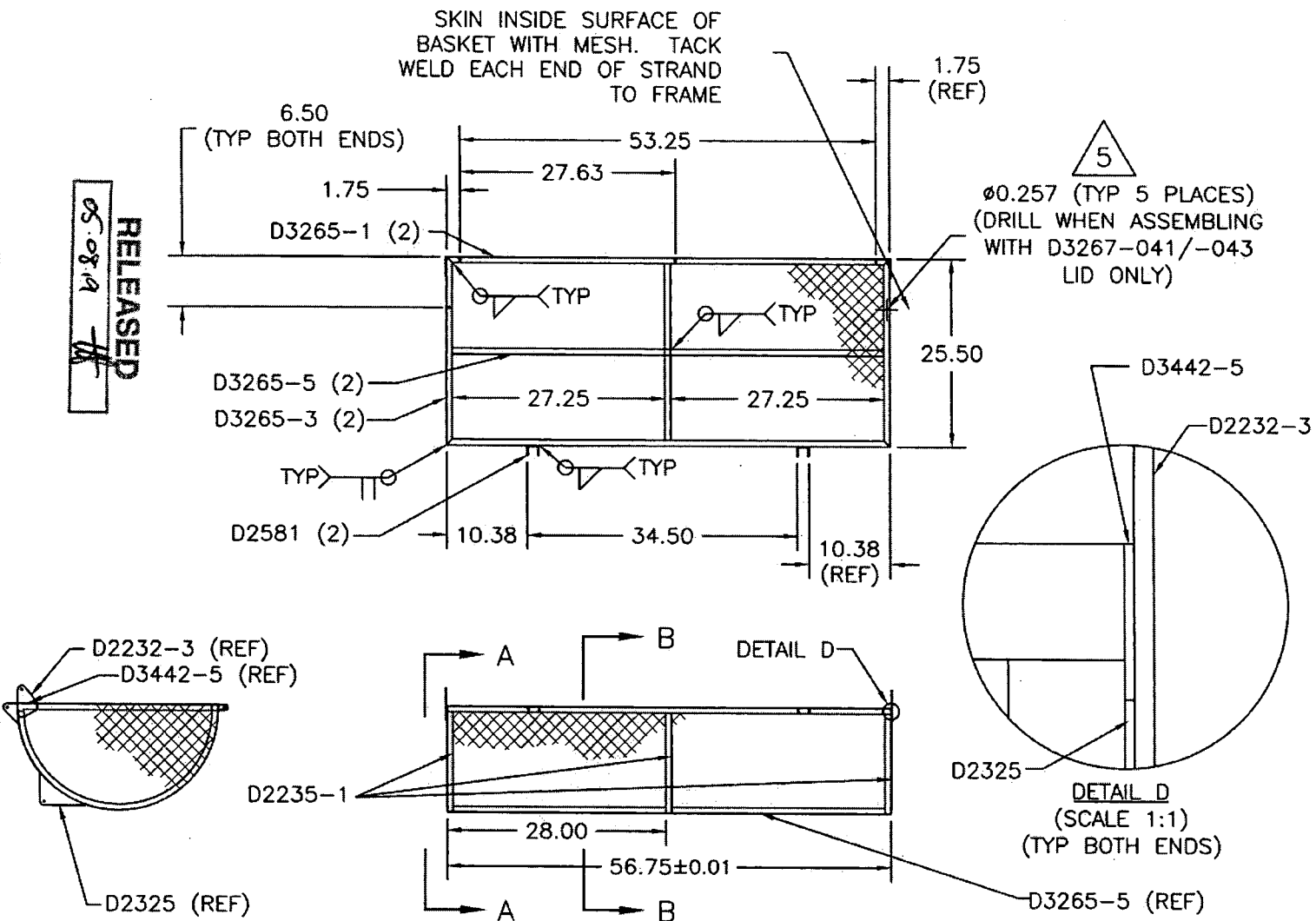
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DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	D3265
DATE	05.06.08	TITLE	BASKET BASE ASSEMBLY (350)		
SCALE	1:20	SHEET	2 OF 3		



D3265-041 BASKET BASE ASSEMBLY

MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
WELD PER DART QSI 004

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

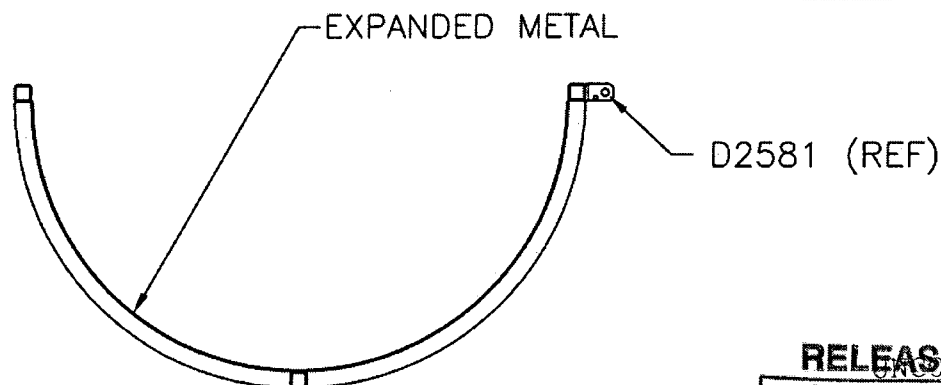
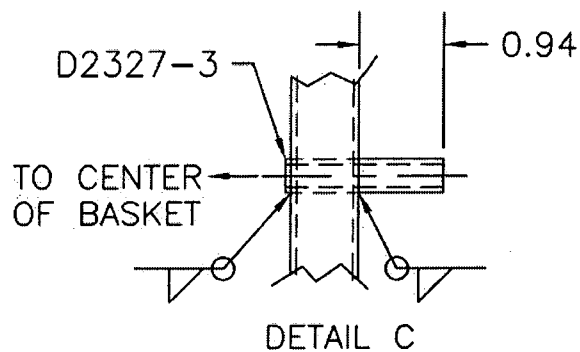
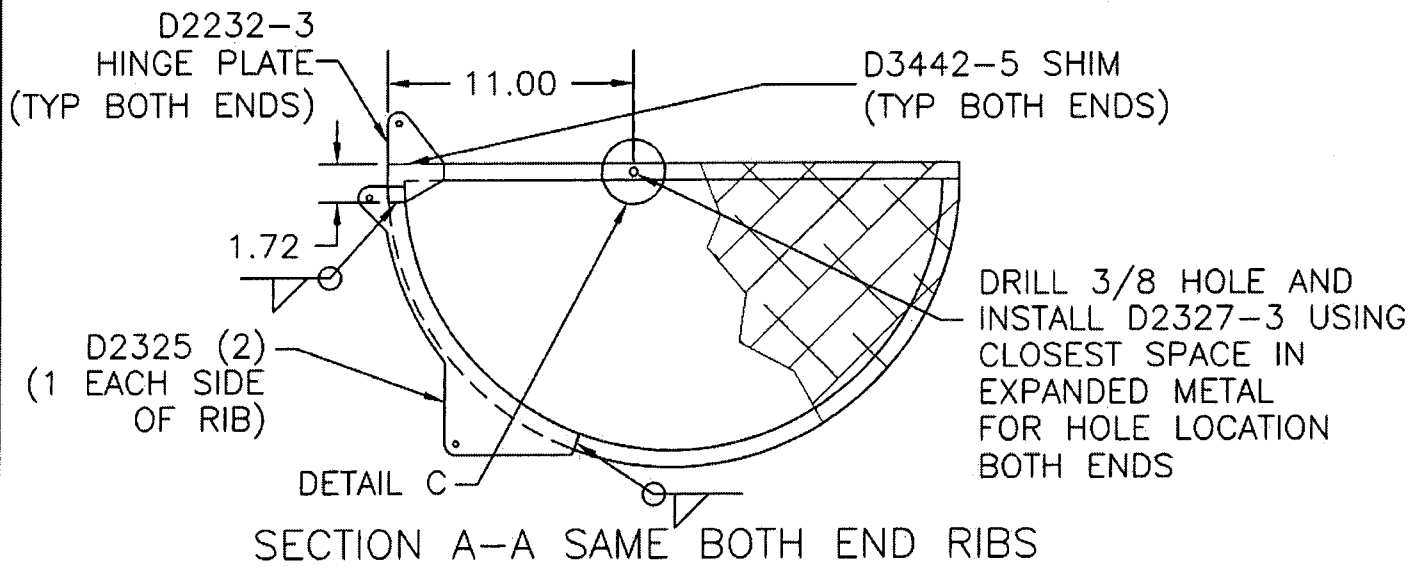
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05.08.09



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3265	REV. B SHEET 3 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION B-B SAME BOTH CENTER RIBS

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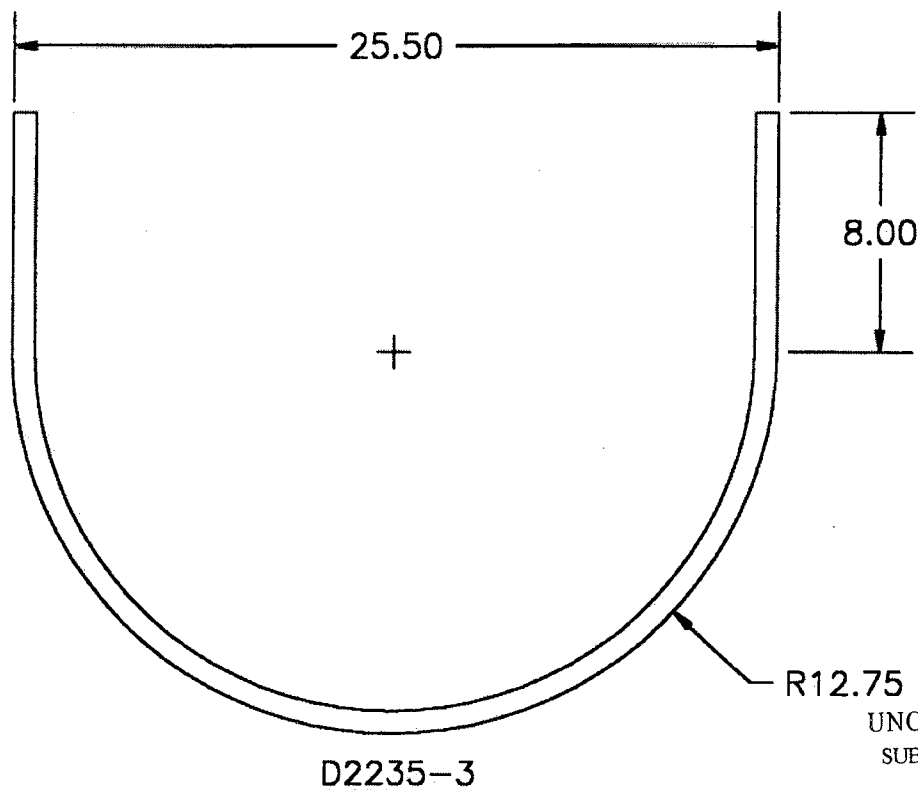
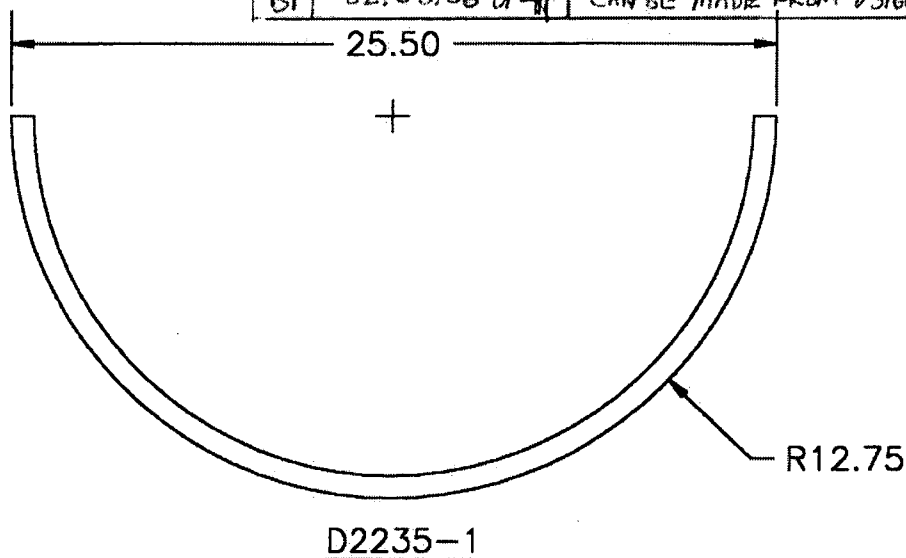
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B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>BW</i>	<i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06 <i>U-#</i>	CAN BE MADE FROM D3166-1	

RELEASED
R 960507



CAN BE MADE FROM D3166-1 *BI*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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NO. 27292A